

# Work Order ID 51448

August 24, 2009 2:28:46 PM



Page 1

Item ID: D3642-1

Accept



Setup Start



Revision ID: B

Stop



Item Name: Doubler

Start Date: 8/25/09 Start Qty: 12.00



Cust Item ID:

Required Date: 8/31/09 Req'd Qty: 12.00



Customer:

References:

Approvals: Process Plan: *W*

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3642

Rev B

14

*(P10) →*

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3642

☐ Dwg Rev: *B*

☐ Prog Rev: *B*

☐ 2-

Deburr if necessary

*B 9-8-17*

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

*B 9-8-17*

*(14)*

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control


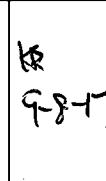

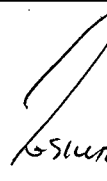
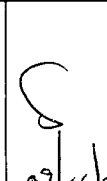
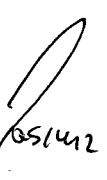

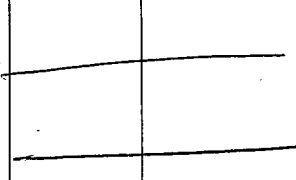
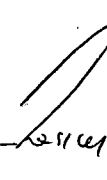
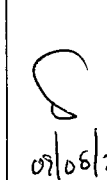
*⇒ 8 or 6/6/05*

*(13) 41 41*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
11							

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
9/6/25	#100	Found qty 11 Part with a cut out from water jet. 2 c. parts were too grouped		Scrap - no replace.	 9-8-17	 09/06/25		 09/06/25
		too close together to same material waste.					 09/06/25	

NOTE: Date & initial all entries

# Work Order ID 51448

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Page 2

Item ID: D3642-1

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Revision ID: B

Item Name: Doubler

Start Date: 8/25/09 Start Qty: 12.00

Required Date: 8/31/09 Req'd Qty: 12.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

Chemical Conversion Coat per QSI005 4.1

0.00

HandFinish

Memo

0.00

Hand Finishing

140

QC3- Inspect Part Finish

0.00

QC

Memo

0.00

Quality Control

150

Identify as per dwg & Stock Location: \_\_\_\_\_

0.00

Packaging

Memo

0.00

Packaging

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 51448

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Page 3

Item ID: D3642-1

Accept



Setup Start



Revision ID: B

Stop



Item Name: Doubler

Start Date: 8/25/09 Start Qty: 12.00



Cust Item ID:

Required Date: 8/31/09 Req'd Qty: 12.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/08/26 HJ

BS 09-8-26 K13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

August 24, 2009 2:28:45 PM

Work Order ID: 51448



Parent Item: D3642-1RevB



Parent Item Name: Doubler

Start Date: 8/25/09

Required Date: 8/31/09

Comments:

Start Qty: 12.00

Required Qty: 12.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M2024T3S.050		Purchased	No			100	sf	141.9800	2.1019			



2024-T3 .050 sheet



<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	141.98	
111381	45.98	
112291	96	

111381

B 9-8-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	51448
<b>Description:</b> DoublER		<b>Part Number:</b>	D3642-1
<b>Inspection Dwg:</b> D3642-1 Rev: B		<b>Page 1 of 2</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

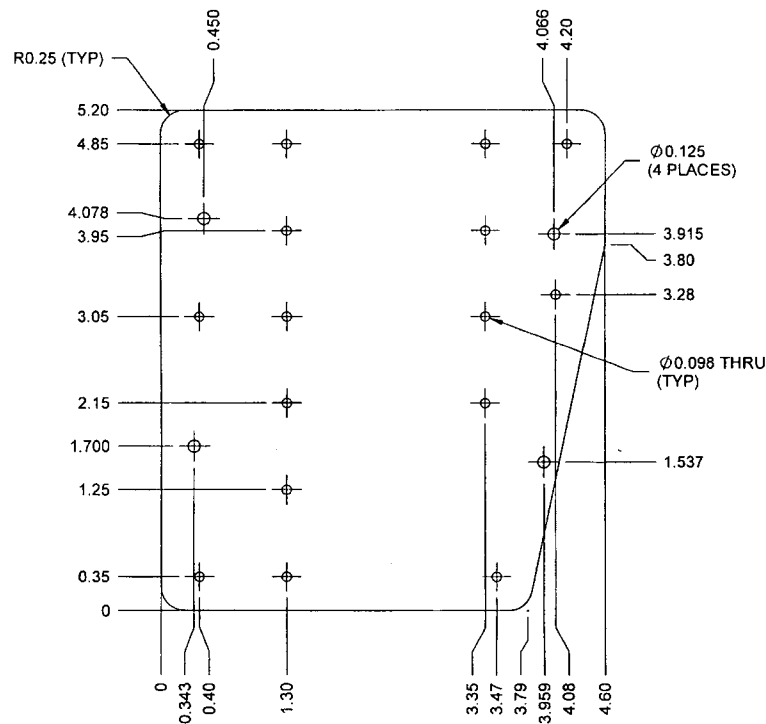
☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .098	+ .004 - .001	.101	✗			
Ø .125	+ .004 - .001	.127	✗			
.35	± .030	.353	✗			
1.25	± .030	1.254	✗			
1.700	± .010	1.701	✗			
2.15	± .030	2.150	✗			
3.05	± .030	3.052	✗			
3.95	± .030	3.957	✗			
4.078	± .010	4.083	✗			
4.85	± .030	4.854	✗			
5.20	± .030	5.206	✗			
.343	± .010	.342	✗			
.140	± .030	.1400	✗			
1.30	± .030	1.305	✗			
3.35	± .030	3.353	✗			
3.47	± .030	3.469	✗			
3.79	± .030	3.785	✗			
3.959	± .010	3.958	✗			
4.08	± .030	4.082	✗			
4.60	± .030	4.603	✗			
4.50	± .010	4.51	✗			
4.066	± .010	4.063	✗			
4.20	± .030	4.20				

<b>Measured by:</b> RB	<b>Audited by:</b> S	<b>Prototype Approval:</b> n
<b>Date:</b> 9-8-17	<b>Date:</b> 09/06/25	<b>Date:</b> 9

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	





**D3642-1 DOUBLER (WAS GENEVA P/N G10607-1/-2)**

**NOTES:**

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.050 THICK PER QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T3S.050)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3642-1" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.11 lbs

**RELEASED**  
07.11.14

B	REMOVE -2; UPDATE -1 TO INCLUDE G10607-2	LE	07.10.16
A	NEW ISSUE; REPLACES G10607	LE	07.07.27
REV.	DESCRIPTION	BY	DATE
DESIGN	TS	<b>DART AEROSPACE USA, INC.</b> PORT HADLOCK, WA	
DRAWN	UG		
CHECKED	AG	DRAWING NO.	REV. B
MFG. APPR.	CG	D3642	SHEET 1 OF 1
APPROVED	TH	TITLE	SCALE
DE APPR.	TH	DOUBLER	4:5
DATE	07.10.16	COPYRIGHT © 2007 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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